

PARTS LIST:

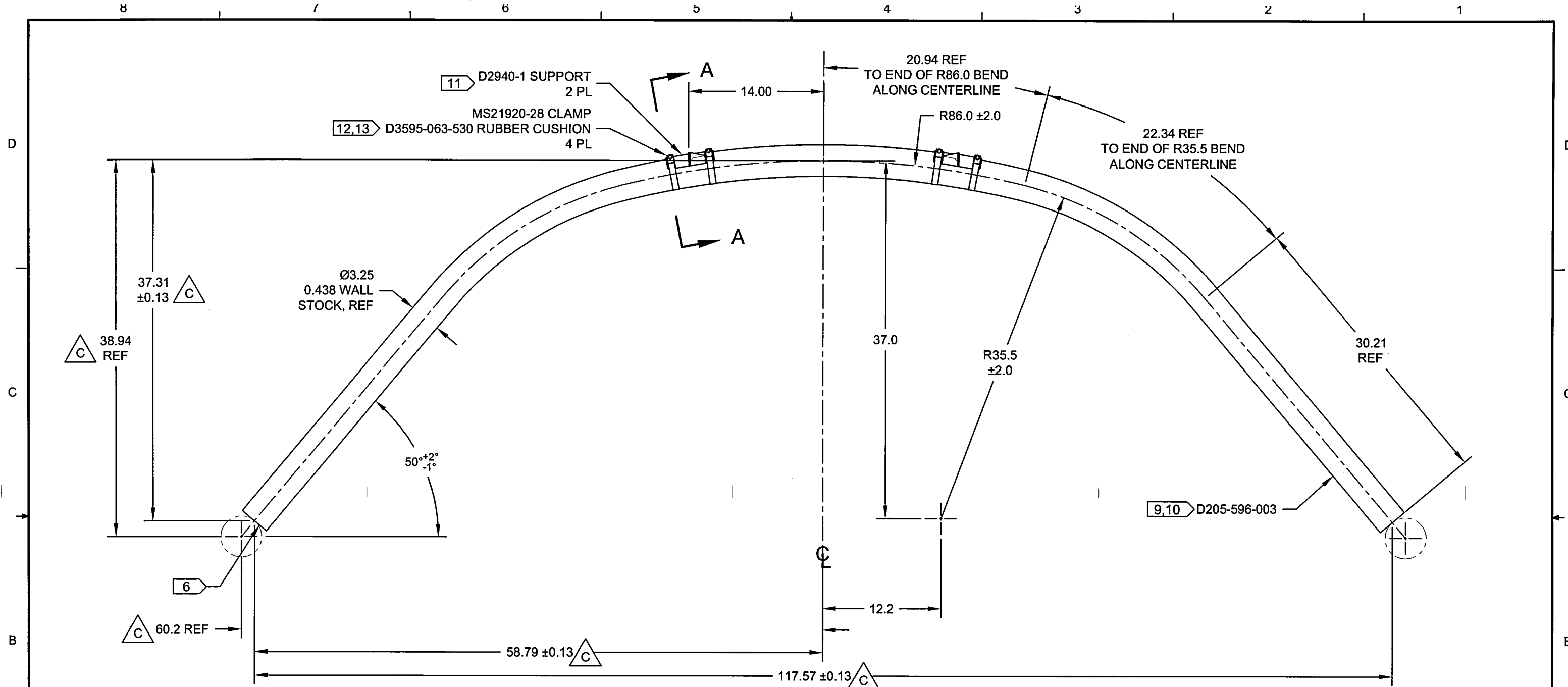
ITEM	QTY -103	QTY -103B	PART NUMBER	DESCRIPTION
	X		D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
		X	D205-596-103B	CROSSTUBE ASSEMBLY, HI-HI AFT, 214
1	1	1	D6008-180	CROSSTUBE
2	2		D2940-1	SUPPORT
3	4	4	D3595-063-530	RUBBER CUSHION
4		2	D5018-1	SUPPORT, 214 AFT
5	4	4	MS21920-28	CLAMP
6	A/R	A/R	PROSEAL 890 B-2	SEALANT (OR AMS-S-8802 CLASS B-2)

GENERAL NOTES:

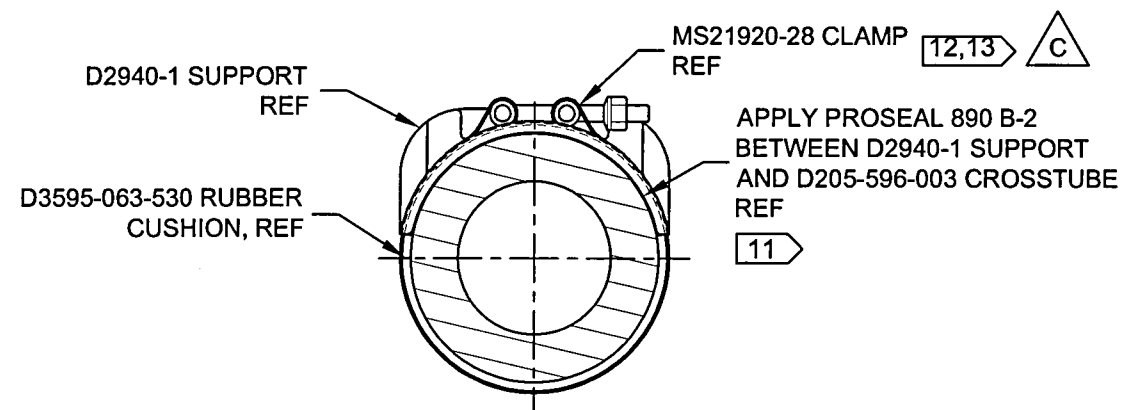
- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) TO INSTALL D2940-1 / D5018-1 SUPPORTS: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 / D5018-1 SUPPORT. ENSURE CLAMP MECHANISMS ARE ON TOP SIDE OF CROSSTUBE.
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER MS21920-XX CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

RELEASED
2018 JAN 24
ECN 18-525

C	REFORMAT, ADD SHT 3, HEIGHT/WIDTH TOL IS. ±0.13 WAS ±0.1, ADD TOTAL WIDTH DIM (B4-2, B4-3), CLAMP ORIENTATION FLIPPED (A5-2, A5-3), INCORP ALL DEO'S	CP	17.08.23
B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	DS	D205-596-103	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	41	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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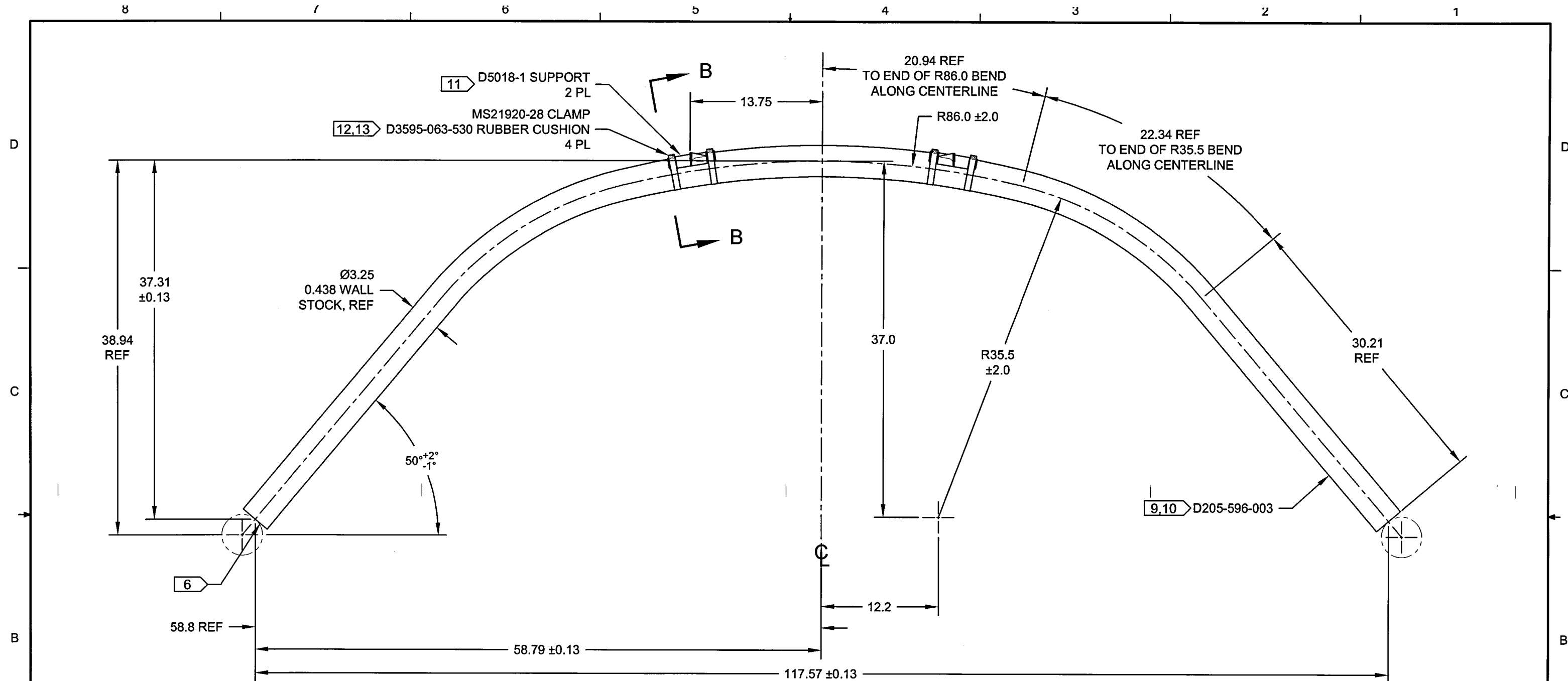
D205-596-103 CROSSTUBE ASSEMBLY, HI-HI AFT



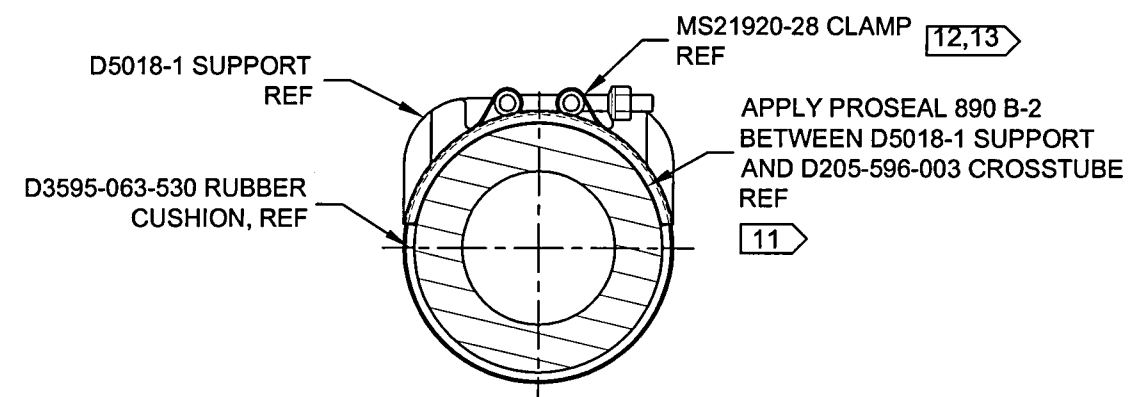
SECTION A-A
SCALE 4X

RELEASED
2018 JAN 24 *qp*

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>qp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DB</i>	D205-596-103	SHEET 2 OF 3
APPROVED	<i>WM</i>	TITLE	SCALE
DE APPR.	<i>qp</i>	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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D205-596-103B CROSSTUBE ASSEMBLY, HI-HI AFT



SECTION B-B
SCALE 4X

RELEASED
2018 JAN 24 *q*

DESIGN	<i>q</i>	DART AEROSPACE LTD	
DRAWN	<i>q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>WMM</i>	D205-596-103	SHEET 3 OF 3
APPROVED	<i>q</i>	TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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